

1-17 AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY

This architectural drawing shows a vertical section of a wall. A dimension line indicates a height of 338 1/2' 6". A callout box labeled '3 1/2" thick' points to the wall's thickness at the bottom. A small triangle symbol is located near the top right corner.

sooth \*

2

05210 3342

A technical line drawing of a vertical pipe assembly. The pipe is shown with a dashed line indicating its center axis. At the top, there is a horizontal branch with a valve symbol. At the bottom, there is a flange with a circular callout containing the number '11'. The drawing is labeled '138' in the bottom right corner.



Date: Thursday, 24/07/2008 8:23:49 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 QC5

INSPECT WORK TO CURRENT STEP



8/08/26 (83)

Comment: INSPECT WORK TO CURRENT STEP

21.0 PACKAGING 1

PACKAGING RESOURCE #1



39952

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

22.0 QC21

FINAL INSPECTION/W/O RELEASE



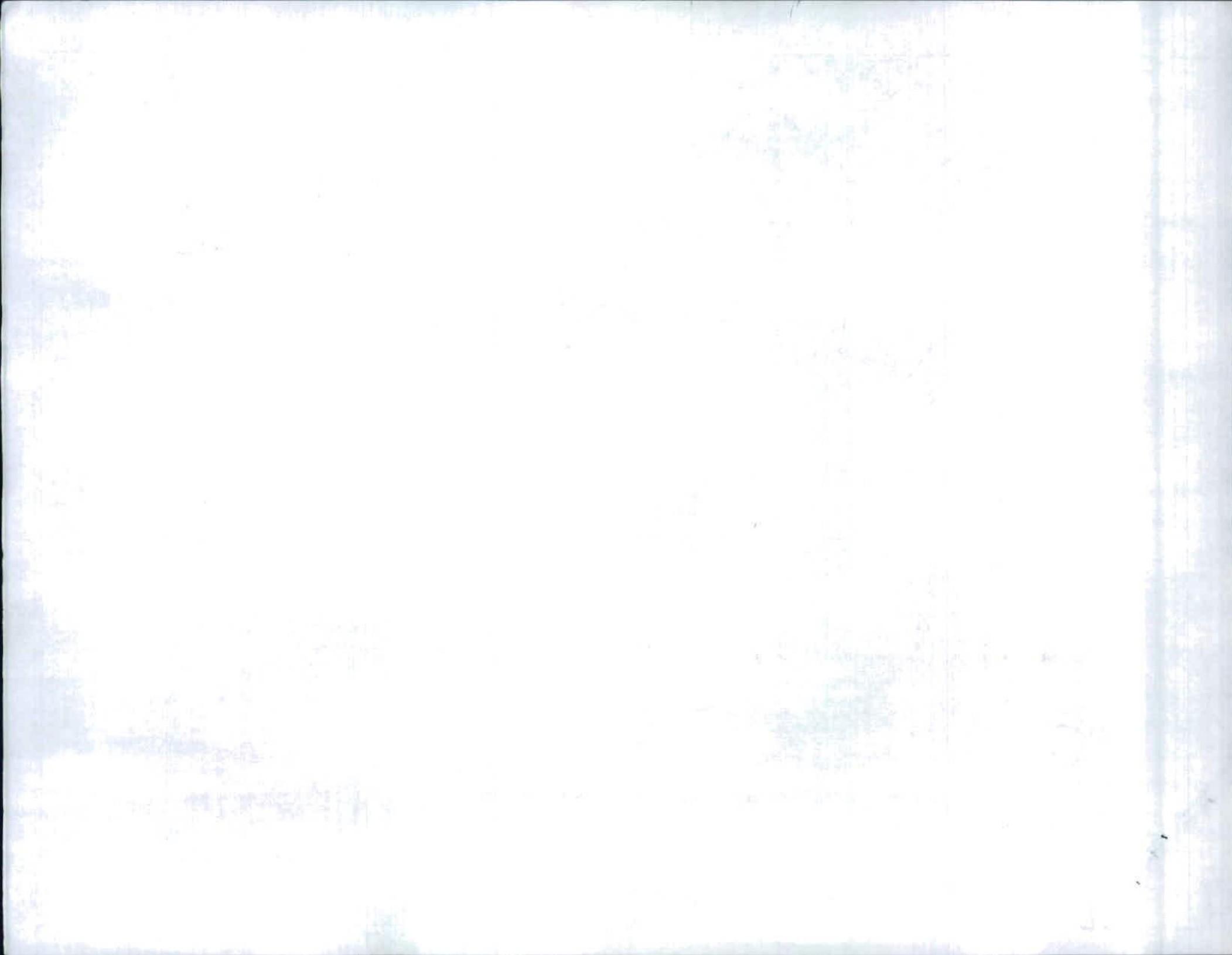
08/08/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



8/08/26



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Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

1-40°F

OVEN TEMPERATURE:

320

FINISH TIME:

2-10

(SD)

m/p

08/07/31

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



FL

08/07/31

(5)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0 PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

20 Degree Cover Plate

batch: 40094

K 08.08.26

5

16.0 PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83

batch: 40096

K 08.08.26

5

17.0 MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: 108986

K 08.08.26

5

18.0 NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: 108473

K 08.08.26

5

19.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



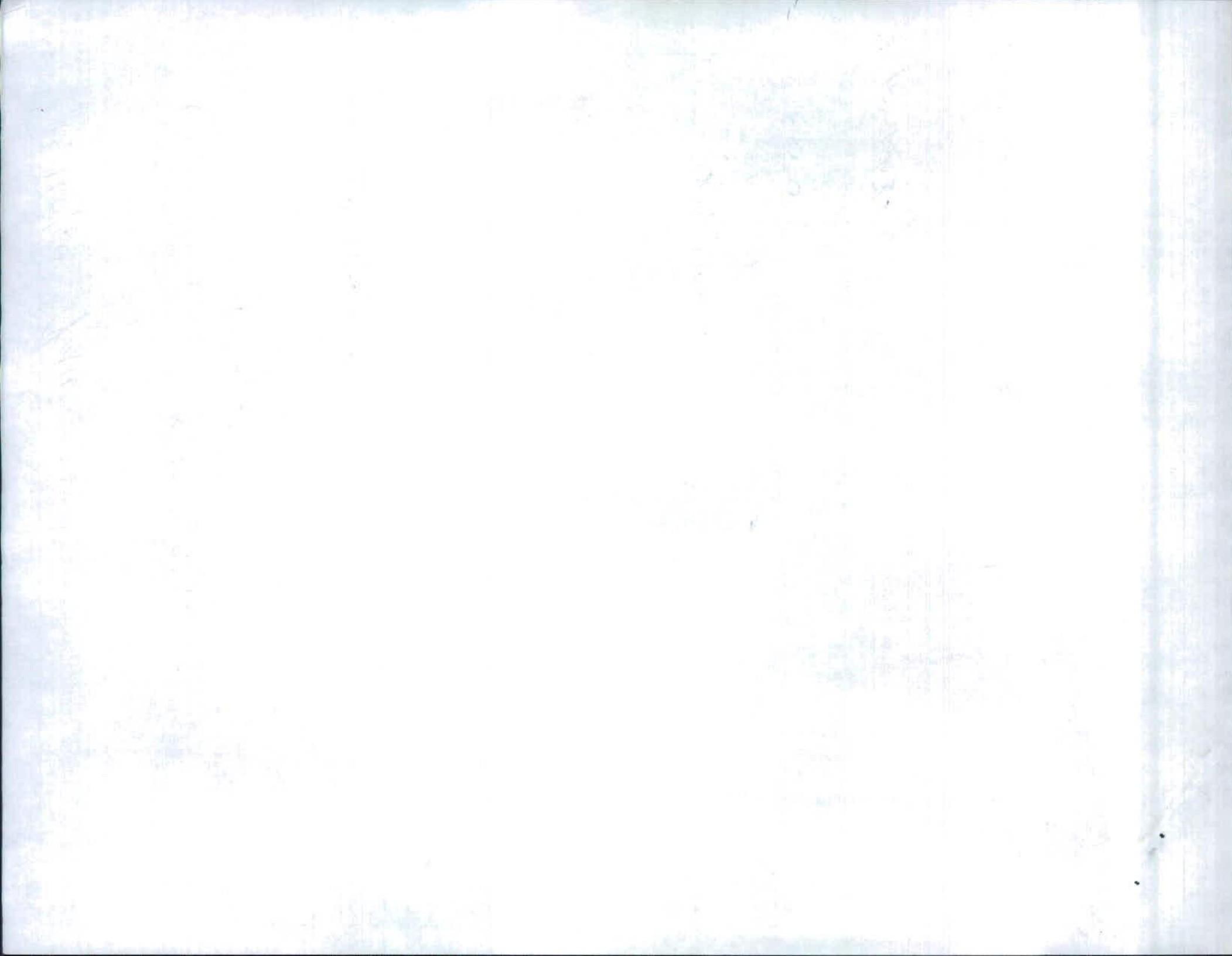
Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

K 08.08.26

5



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Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

1/2 08-07-24 5

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PB 080120(3)

8.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/07/20(8) X

Comment: INSPECT WORK TO CURRENT STEP

9.0 MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
HELICAL INSERT

M 1935

b/f 08-07-30

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- tap drill for helical
- 3- install helical insert as per dwg

BR 08-07-30

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/30 (3)

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a/a S.

13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

(5x)

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

m-f 08/07/31

Hadi

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## Process Sheet

Duplicate

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY	
Job Number	: 40608-2		Part Number	: PB674300115	
Estimate Number	: 13433		Drawing Number	: B6743001 P.7	
P.O. Number	:		Project Number	: N/A	
This Issue	: 24/07/2008 S.O. No. :		Drawing Revision	: B1	
Prsht Rev.	: NC		Material	:	
First Issue	: 17/07/2008 Type : LARGE FAB ASSY		Due Date	: 24/07/2008 Qty: 3	
Previous Run	:		Um:	Each	
Written By	:				
Checked & Approved By	: MF 08-07-24				
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001257	Inner Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube batch: 40585	
2.0	PB6743001249	Inner Tube Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube Bushing batch: m18141	
3.0	PB6743001253	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340045	
4.0	PB6743001254	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340053	
5.0	PB674300171	PB67-43001-71	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-71 batch: 340027	